

5/25

①

DART AEROSPACE LTD	Work Order:	23285
Description: Bracket	Part Number:	D3264-1
Dwg: D3264 Rev. A	Qty:	51 50
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	OK	05.05.13	50
2	MV	Cut blanks: 4.500" x 1.250" x 5.700" long Bar Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick (M6061T6B1.250x04.500) Identify for D3264-1	J.L.	05/05/24	53
		Batch: M16391 M17625			50
3	MV	Machine as per Folio FA447 and Dwg D3264 Identify as D3264-1	SD	05.05.31	50
4	QC2	Inspect parts as they come off the CNC machine	SD	05.05.31	50
5	QC8	Second check	OK	05.06.01	51
6	MV	Deburr	SD	05.05.31	51
7	QC5	Inspect work to Step 6	2	05.06.07	51
8	FP	Chemical Conversion Coat as per QSI 005 4.1	FF	05.06.07	51
9	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	MFC	05/06/09	51
10	QC3	Inspect Powder Coat	M	05.06.09	51
11	ST	Identify and Stock <i>Identify with Part: Brake H# using AFINE Point Permanent Marker.</i>	DL	05/06/23	51
12	AC	Cost / part 25.45	SAC	05-06-24	51
13	DC	Close W/O 26.12 Inspect Level 21	OK	05.06.30	51


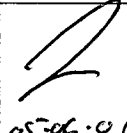
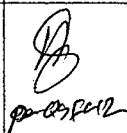
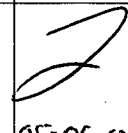
PTO

CZ

Rev	Date	Change	Revised By	Approved
A	04.09.02	New issue	KJ/JLM	

RELEASED
05/06/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 23285		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05.05.31	3	2 scrap - moved in piece (worn inserts pulled piece up)		Scrap & destroy & replace inserts	SD 05.06.01	 05-06-01	 05-06-01	 05-06-01

Part No: D3264-1PAR #: 1Fault Category: Prod / Machine

Part 5

NCR:

Yes ☒ No ☐DQA: Date: 05/06/30

NOTE: Date & initial all entries

QA: N/C Closed: Date: 05.06.30

DART AEROSPACE LTD		Work Order:	23285
Description: Bracket		Part Number:	D3264-1
Inspection Dwg: D3264	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	0.688	✓		Vern	
0.063	+/-0.010	0.062	✓		Vern	
0.125	+/-0.010	0.120	✓		Vern	
0.875	+/-0.010	0.876	✓		Vern	
0.062	+/-0.010	0.063	✓		Vern	
R0.03	+/-0.030	R0.030	✓		R-G	
R0.13	+/-0.030	R0.125	✓		R-G	
1.00	+/-0.030	1.000	✓		Vern	
0.125	+/-0.010	0.125	✓		Vern	
0.600	+/-0.010	0.597	✓		Vern	
4.000	+/-0.005	4.001	✓		Vern	
0.750	+/-0.010	0.751	✓		Vern	
Ø0.194	+0.005/-0.000	Ø0.194	✓		Vern	
5.50	+/-0.030	5.499	✓		Vern	
0.125	+/-0.010	0.125	✓		Vern	
0.063	+/-0.010	0.063	✓		Vern	
R0.25	+/-0.030	R0.250	✓		R-G	
4.27	+/-0.030	4.270	✓		Vern	
R0.30	+/-0.030	R0.300	✓		R-G	

Measured by: <i>ml</i>	Audited by: <i>GP</i>	Prototype Approval:	N/A
Date: 05/05/28	Date: 05/05/28	Date:	N/A

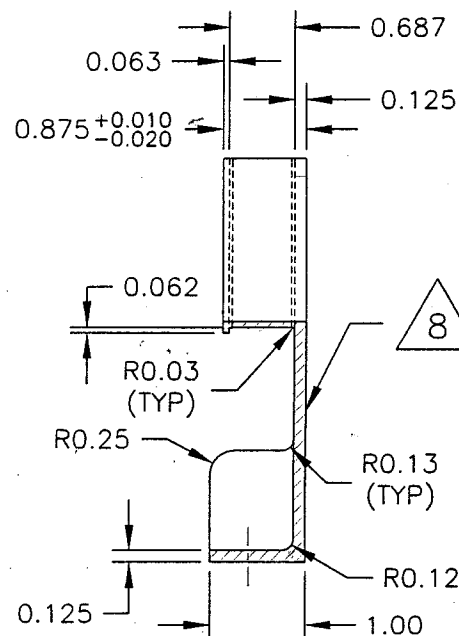
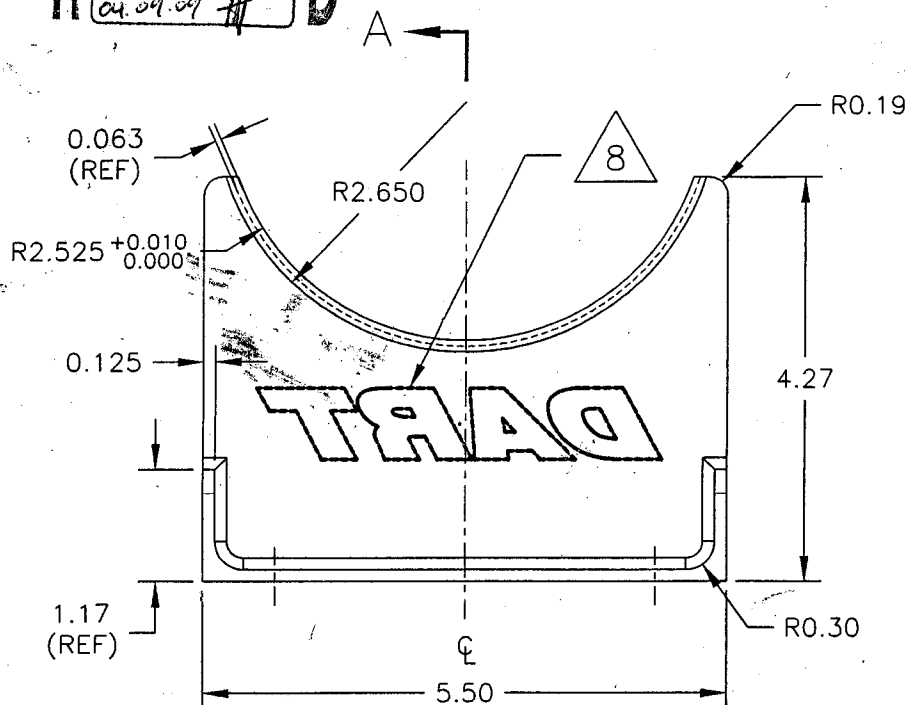
Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.04.26	Ø0.194 was Ø0.208; dimensions removed	KJ/JLM	

RELEASED
05/05/28

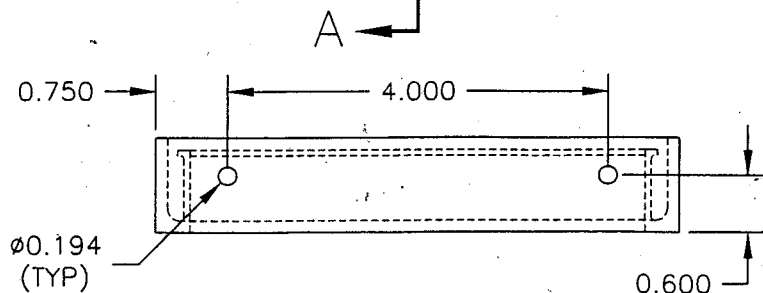


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3264	REV. A SHEET 1 OF 1
DATE 04.04.20		TITLE BRACKET	SCALE 1:2
A	04.04.20	NEW ISSUE	

RELEASED
04.04.09 #



SECTION A-A



D3264-1 BRACKET

D3264-1:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) (MIN) TOOL RADIUS OF 0.25

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

23285

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 12, 2005
04:28 pm

Work Order No : 0023285
Project Name : D3264-1
Project For : WK525
Work Order Type : Main
Main WO Number :
House Part Number : D3264-1
Description : Bracket
Manufactured : Yes
Amount Req'd : 50
Amount Done : 0
Start Date : 05-12-05
Est Finish Date : 06-23-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00